



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3254-2

Job Sheet 167934



Part No: D3254-2

Job Qty: 2 ea

Part Name: Side RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/8/17

Job Tracking No:

Due Date: 12/1/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/30/17	0.00	0.00	Start Up Waterjet1		OK 17/12/02
100	Waterjet	2 pcs		11/30/17	0.00	0.51	Waterjet1		OK 17/12/02
110	QC	2 pcs		11/30/17	0.00	0.00	QC2		OK 17/12/02
120	QC	2 pcs		11/30/17	0.00	0.00	QC8		OK 17/12/02
130	Small Fab	2 pcs		11/30/17	0.08	0.23	Small Fab		SB 17/12/07
140	QC	2 pcs		11/30/17	0.00	0.00	QC5		SB 17/12/07
150	HandFinish	2 pcs		11/30/17	0.00	0.20	HandFinish1		BEB 17/12/11
160	Powdercoat	2 pcs		12/1/17	0.00	0.12	Powdercoat4		BR 17/12/12
170	QC	2 pcs		12/1/17	0.00	0.00	QC3		38
180	Packaging	2 pcs		12/1/17	0.00	0.00	Packaging3		Smr 17/12/12
190	QC21-SA	2 Ea		12/1/17	0.00	0.00	QC21		DEC 12 17

Part Op 100 - 1-Cut D3254-1as per Dwg D3254

Descriptions: 130 - Bend as per dwg D3254

160 - START TIME:

1.20 OK T: 500° FINISH 1.50 M 135 H18. ST 047

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.063	13	309	0	0

Part Specifications

Specifications could not be found.

Plex 11/8/17 11:08 AM Dart.lajeunesse.marie

DQA:

Date: _____

QA Closed:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order:

PART NO:
Revision:
Operation:
Change No:

D3254 - 2

Start up Operation

Mfg Date: 12/03/17
Job No: 167934

DISPOSITION

DART
AEROSPACE
S016592

Side RH

ork
rap
s-is
red

AGAINST DEPARTMENT/PROCESS

Skid-tube
Machining
Thermoforming
Large Fab

Cross tube
Small Fab
Finishing
Composite

Water Jet
Prod. Eng. Coord.
Rec/Store/Packaging
Supplier

Engineering
Quality
Other

QTY Effective :

Disposition

MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

FAULT CATEGORY

Temperature/Cure

Set-up

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Power Loss/Surge

Folio/Program

Grain

Weld

Wrong Stock Pulled

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

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CANADA
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Email: sales@dartaero.com
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Marks/Chatter

Manufacturing Process

Past Due

OTHER :

Substa

Past Expiry Date

Misidentified

Envi

Do

Equip/T

Handlin

Ma

Internal Tran

Tribal Knowl

DART AEROSPACE LTD		Work Order: 167934
Description: Side (Dual Battery Rack)		Part Number: D3254-2
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.20	1		V: M-02	
4.15	+/-0.030	4.15	1		V: M-01	
R0.19	+/-0.030	.19	1		Tap	
1.103	+/-0.010	1.100	1			
0.300	+/-0.010	.299	1			
Ø0.098	+0.005/-0.000	.099	1			
1.300 Pitch	+/-0.005	1.298	1			
21.056	+/-0.010	21.056	1			
19.000	+/-0.010	19.000	1			
1.003	+/-0.010	1.009	1			
Ø1.125	+0.005/-0.000	1.124	1			
5.403	+/-0.010	5.402	1			
Ø1.500	+0.005/-0.000	1.499	1			
2.750 Pitch	+/-0.005	2.749	1			
5.500	+/-0.010	5.498	1			
1.653	+/-0.010	1.663	1			
3.75	+/-0.030	3.75	1			
10.810	+/-0.010	10.808	1			
8.00	+/-0.030	8.00	1			
R0.50	+/-0.030	.50	1			
2.750 Pitch	+/-0.005	2.748	1			
4.125	+/-0.010	4.129	1			
22.946	+/-0.010	22.946	1			
R0.30	+/-0.030	.30	1			
9.90	+/-0.030	9.90	1			
11.77	+/-0.030	11.77	1			
1.82	+/-0.030	1.82	1			
2.17	+/-0.030	2.17	1			
20.10	+/-0.030	20.10	1			
0.953	+/-0.010	.949	1			
R0.125	+/-0.010	.125	1			
Grain along 20.10	N/A					

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 17/12/02	Date: 17-12-07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								